

Date: Friday, 18/07/2008 1:10:35 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : JOGGLE BRACKET
 Job Number : 40656
 Estimate Number : 12912
 P.O. Number :
 This Issue : 18/07/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D35801
 First Issue : / / Type : SMALL / MED FAB Drawing Number : D3580 REV B
 Previous Run : 38648 Project Number : N/A
 Material :
 Due Date : 31/07/2008 Qty: 40 Um: Each
 Written By :
 Checked & Approved By : JUL 08.7.18
 Comment : Est Rev : A New Issue 07.06.25 EC
 Est Rev : B Removed Powder Coat 07-07-11 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S18GA 304/316 .050 Sheet



Comment: Qty.: 0.0105 sf(s)/Unit Total : 0.4200 sf(s)

304/316 SS sheet 0.050" thick

Batch: 100997 B 8-7-21

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3580

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: Bend as per dwg D3580 using 1/8" offset die

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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Drawing Name: JOGGLE BRACKET

Job Number: 40656

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



counter

Comment: INSPECT WORK TO CURRENT STEP

S 08/09/22 (x112)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 110

Pc 8/7/22 (112)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/23

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-23

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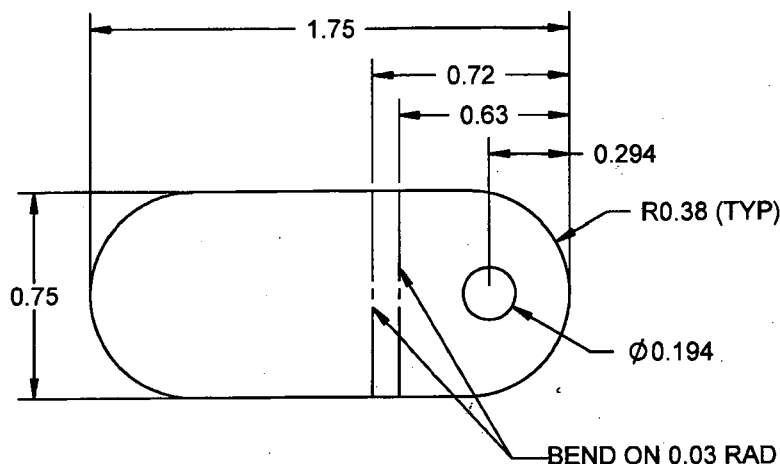
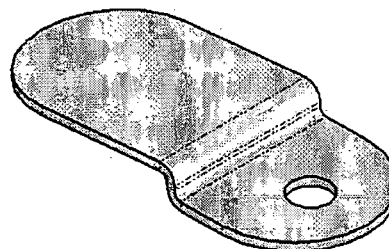
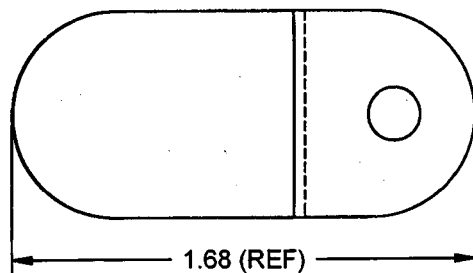
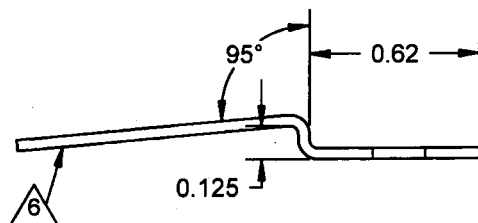
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NOTE: Date & initial all entries

DART

| | | | |
|----------------------|--------------------------------|---|------------------------|
| DESIGN <i>LE</i> | DRAWN BY <i>CB</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>LE</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3580 | REV. B SHEET 1 OF 1 |
| DATE 07.07.09 | | TITLE JOGGLE BRACKET SCALE 3:2 | |
| REV | DATE | DESCRIPTION | |
| A | 07.05.15 | NEW ISSUE | |
| B | 07.07.09 | REMOVE POWDER COAT | |

RELEASED07.07.09 *[Signature]***D3580-1F FLAT PATTERN****D3580-1 JOGGLE BRACKET****NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK)
PER MIL-S-5019 (REF DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3580-1" USING FINE POINT PERMANENT INK MARKER
ON THE UNDERSIDE OF THE PART AS INDICATED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *40650*

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